

# Work Order ID 67825

Thursday, March 31, 2011 1:01:40 PM



Page 1

Item ID: D3823-3KGY

Accept



Setup Start



Revision ID:

Item Name: Overhead Rear, Center-Grey

Stop



Start Date: 3/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *MF* Date: *11-03-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2

*B* 11/04/02

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: *140*

Time IN: *4:30*

Time OUT: *7:00*

*11/04/02*  
*11/04/02*

*B* 11/04/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 67825

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Page 2

Item ID: D3823-3KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Overhead Rear, Center-Grey

Start Date: 3/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA031 using tool DT9110  
Dwg Rev: C  
Folio Rev: C

2

1

BB

11/04/02

P.h. →

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

2

BB

11/04/02

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

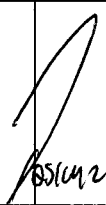



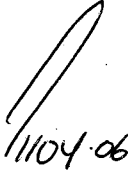
Quality Control

2

P.h.  
11/04/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3823-3464 PAR #: \_\_\_\_\_ Fault Category: Thermal Fw m.p. NCR: Yes No DQA: \_\_\_\_\_ Date: 11/04/06  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 11/4/6

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/02	110	PART OVERHEATED in CENTER & caused blisters. R.E. Process / 1st part.		lower SET Temp from 308° TO 295°	 11/04/02	 11/04/06	 11/04/02	 11/04/06

NOTE: Date &amp; initial all entries



**Work Order ID 67825**

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Item ID: D3823-3KGY

Accept

Revision ID:

Item Name: Overhead Rear, Center-Grey

Start Date: 3/31/2011 Start Qty: 2.00

Required Date: 4/6/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

Memo

PDP PO 4607

0.00

4/4/11 (2)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/11

MF  
11-04-05

# Picklist Print

Thursday, March 31, 2011 1:01:36 PM

Page 1

Work Order ID: 67825



Parent Item: D3823-3KGY



Parent Item Name: Overhead Rear, Center-Grey

Start Date: 3/31/2011

Required Date: 4/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC  
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	523.2500	10.625	21.26063 10.625			

Kydex steel grey

Location

therm

111807

Loc Qty

523.25

523.25

Loc Code

2+1  
36.885635g PL  
11/04/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

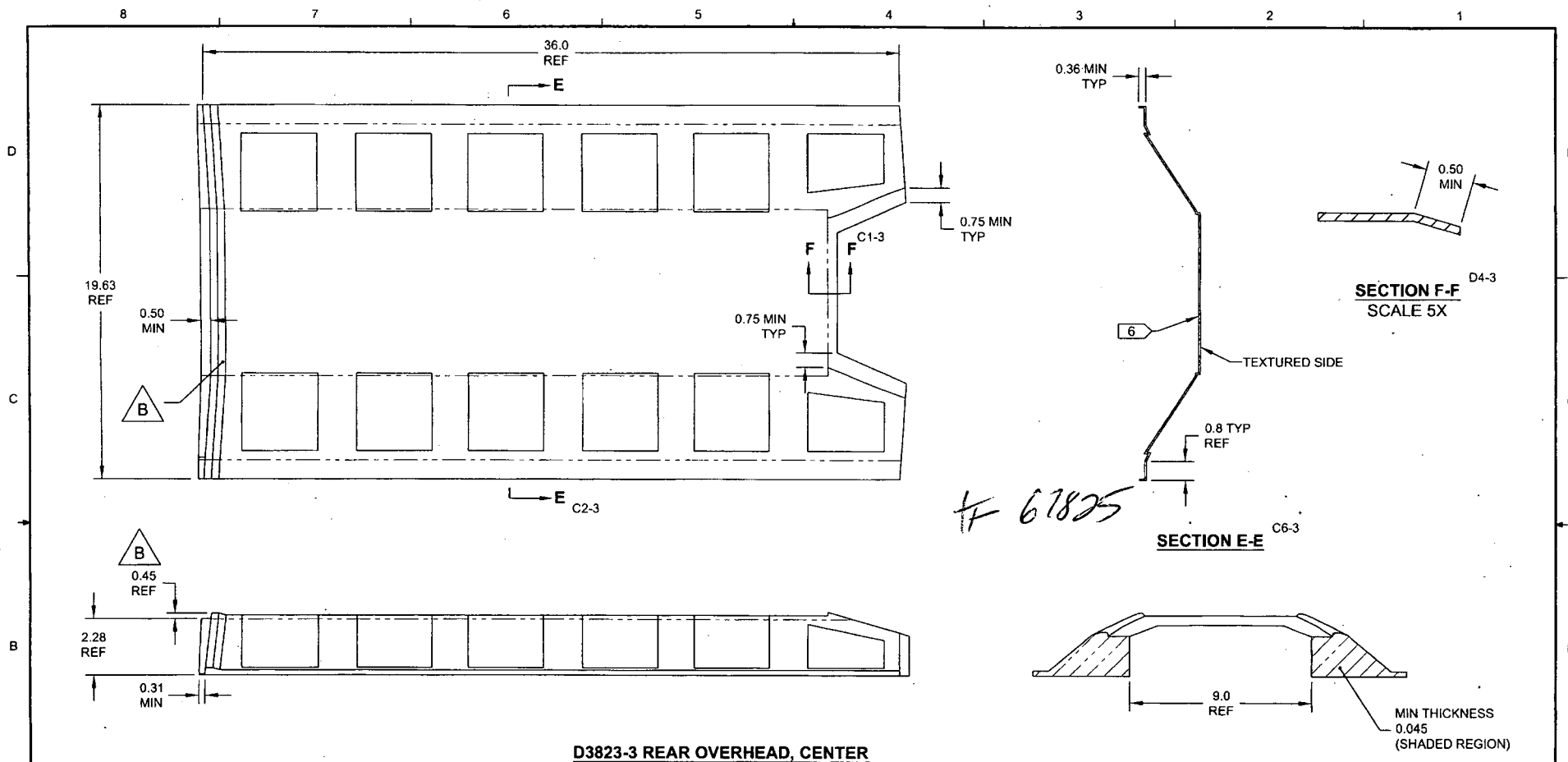
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3823-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3823	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	REAR OVERHEAD	NTS
DATE	09.05.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RE-USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED  
9/5/12

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 67825
<b>Description:</b> Rear Overhead, Center		<b>Part Number:</b> D3823-3KIV/KGY
<b>Inspection Dwg:</b> D3823	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

<b>Measured by:</b> BB	<b>Date:</b> 11/04/06
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	.60	✓			
0.75	Min	.75	✓			
0.36	Min	.41	✓			
0.50	Min	.61	✓			
0.045	Min	.57	✓			
0.055	Min	.59	✓			

<b>Measured by:</b> BB	<b>Date:</b> 11/04/06
<b>Audited by:</b> DL	<b>Date:</b> 11/04/06
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	MA